

Work Order ID 81674

March-16-12 1:57:49 PM

Ship March 22  
\*81674\*

Page 1

Item ID: D4106-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Sill Doulber, LH

Start Date: 16/03/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/16 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4106

A

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

12-3-20

⑦

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

12-3-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81674

March-16-12 1:57:50 PM

**\*81674\***

Page 2

Item ID: D4106-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Sill Doulber, LH  
 Start Date: 16/03/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 22/03/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				7			
130 <b>*130*</b> Small Fab Small Fab	1- C'sink holes as per dwg 2- Use press to start forming D4106-1 as per dwg using DT9646. Then finish the shape of D4106-1 by hand.  Memo	0.00  0.00				7	FF	12-04-02	
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo ***Use DT9646 for inspection***	0.00  0.00				7			

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Page 3

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 Revision ID: Stop **\*NS2\***  
 Item Name: Sill Doulber, LH  
 Start Date: 16/03/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 22/03/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>127</u>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							JB (7) 12/04/03
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							12/4/3
Quality Control									

12-04-3

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

March-16-12 1:57:53 PM

Page 1

Work Order ID: 81674

\*81674\*

Parent Item: D4106-1

\*D4106-1\*

Parent Item Name: Sill Doulber, LH

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	191.1180	0.2109	1.332			

\*M304S18GA\*

304/316 .050 Sheet

\*\*

B12-3-20

Location

Loc Qty

Loc Code

MAT020

191.118

119032

10.3

119383

60.818

120604

120

119032

7

# Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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**NOTE:** Date & initial all entries





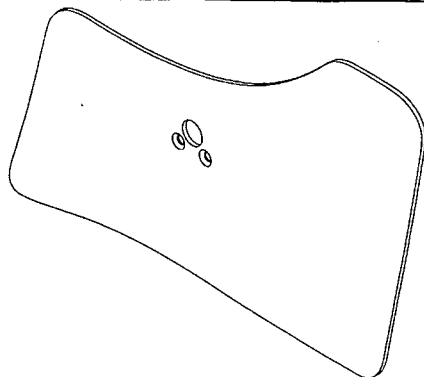
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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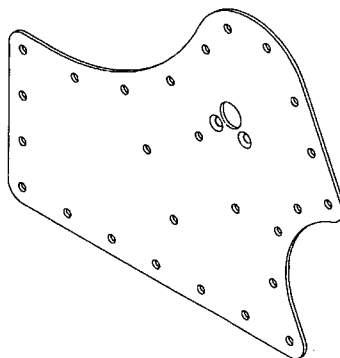
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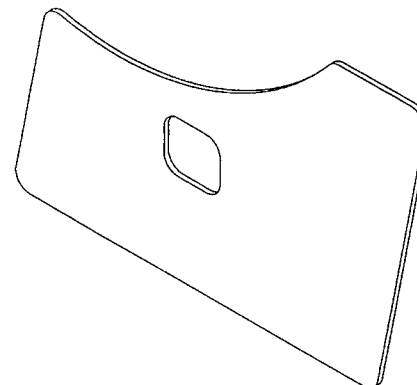
**NOTE:** Date & initial all entries



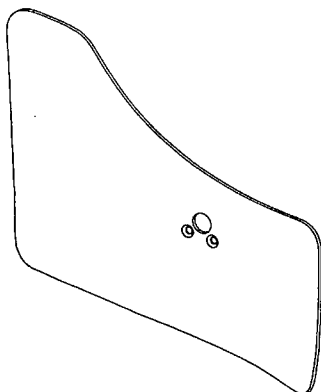
**D4106-1 SILL DOUBLER, LH**



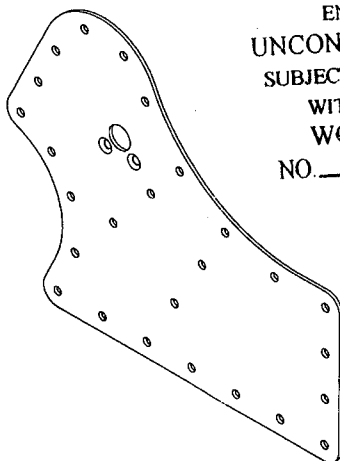
**D4106-3 CREW DOOR DOUBLER, LH**



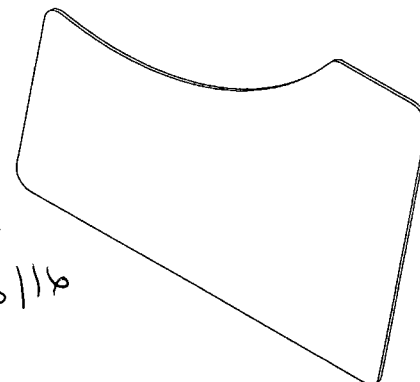
**D4106-5 SPACER, SILL DOUBLER**



**D4106-2 SILL DOUBLER, RH**



**D4106-4 CREW DOOR DOUBLER, RH**



**D4106-7 TEMPLATE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81634 MLC

12/03/16

**RELEASED**  
2010-09-23  
M

A	NEW ISSUE	JPH	10.07.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	<b>D4106</b>	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	<b>DOUBLERS</b>	NTS
DATE	10.07.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

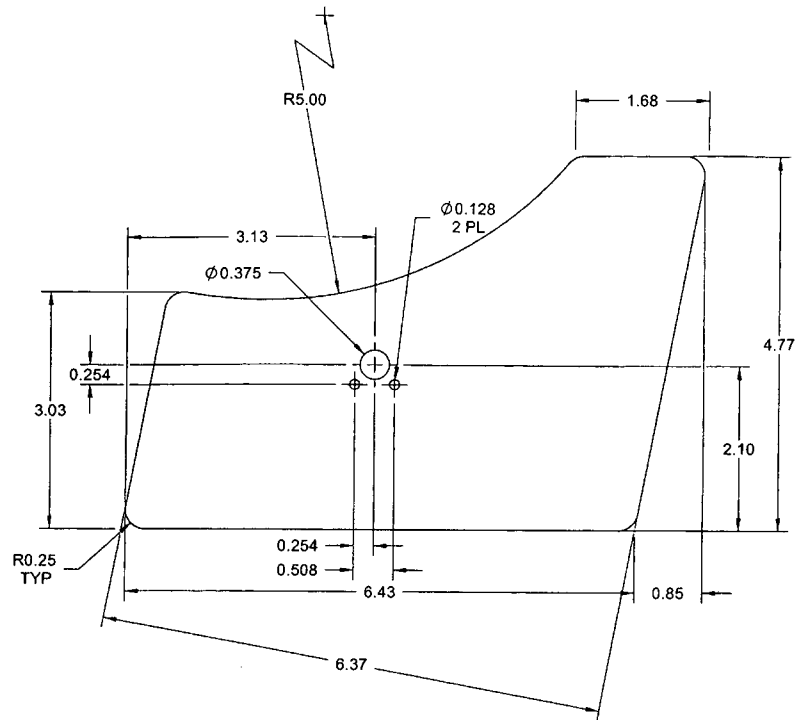
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

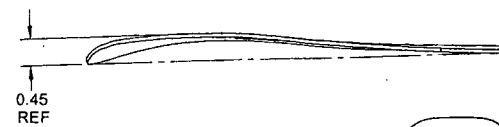
**NOTE:** Date & initial all entries



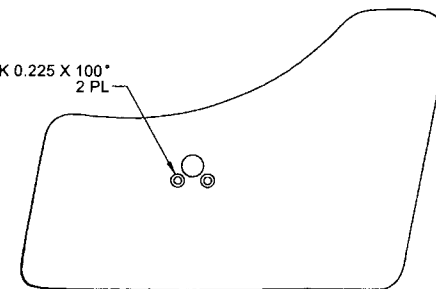
**D4106-1F FLAT PATTERN, SILL DOUBLER**

**NOTES:**

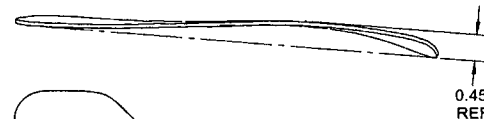
- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA OR M303S18GA  
-1 & -2: MAKE FROM D4106-1F.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -1 & -2: IDENT P/N D4106-X AND B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.34 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9646 FOR D4106-1  
DT9647 FOR D4106-2



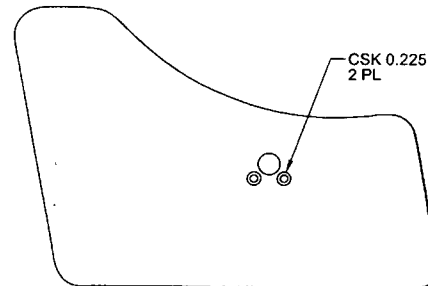
CSK 0.225 X 100°  
2 PL



**D4106-1 SILL DOUBLER, LH** (MAKE FROM D4106-1F)



CSK 0.225 X 100°  
2 PL



**D4106-2 SILL DOUBLER, RH** (MAKE FROM D4106-1F)

**RELEASE**  
2010-09-13

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. <b>D4106</b>	REV. A
MFG. APPR.	JPH		SHEET 2 OF 5
APPROVED	JPH	TITLE <b>DOUBLERS</b>	SCALE NTS
DE APPR.	JPH		
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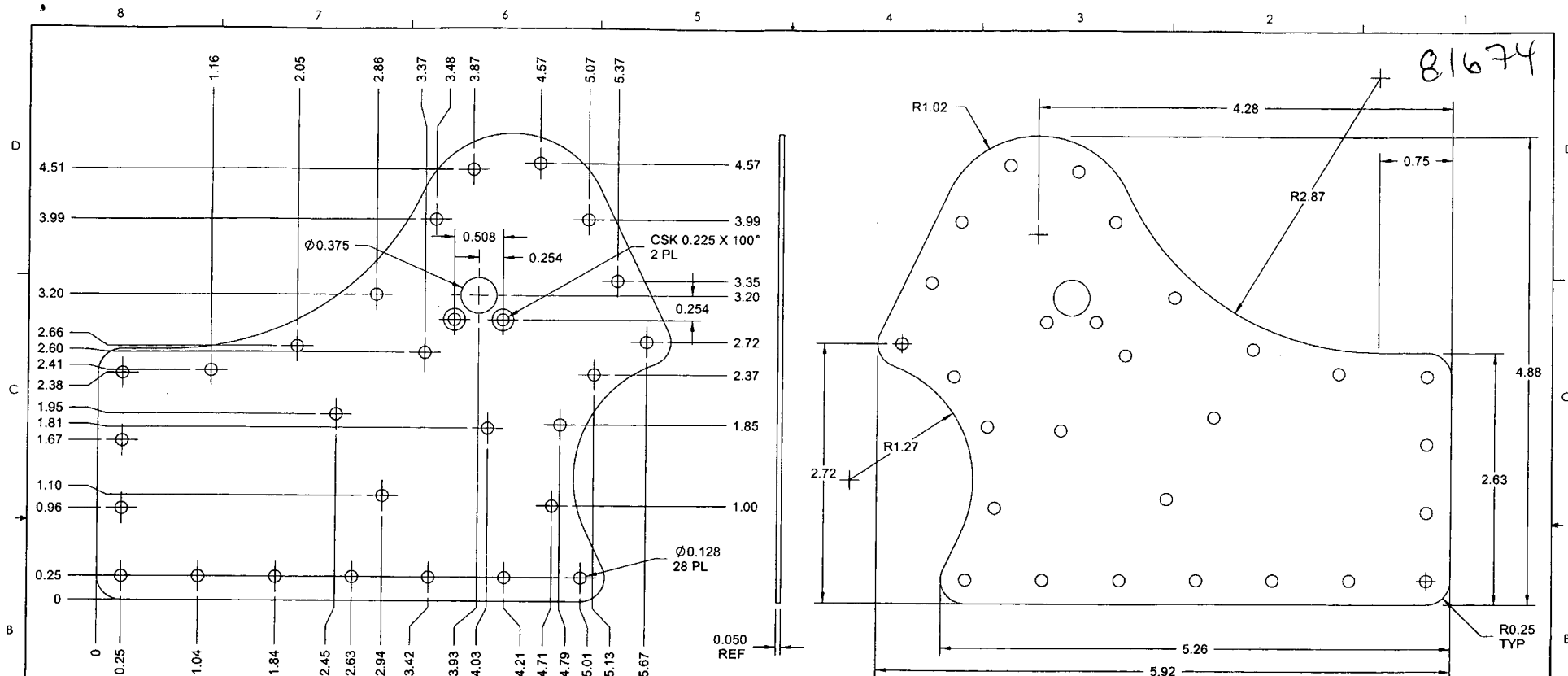
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4106-3 CREW DOOR DOUBLER, LH**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-3 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

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2010-09-23

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DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4106</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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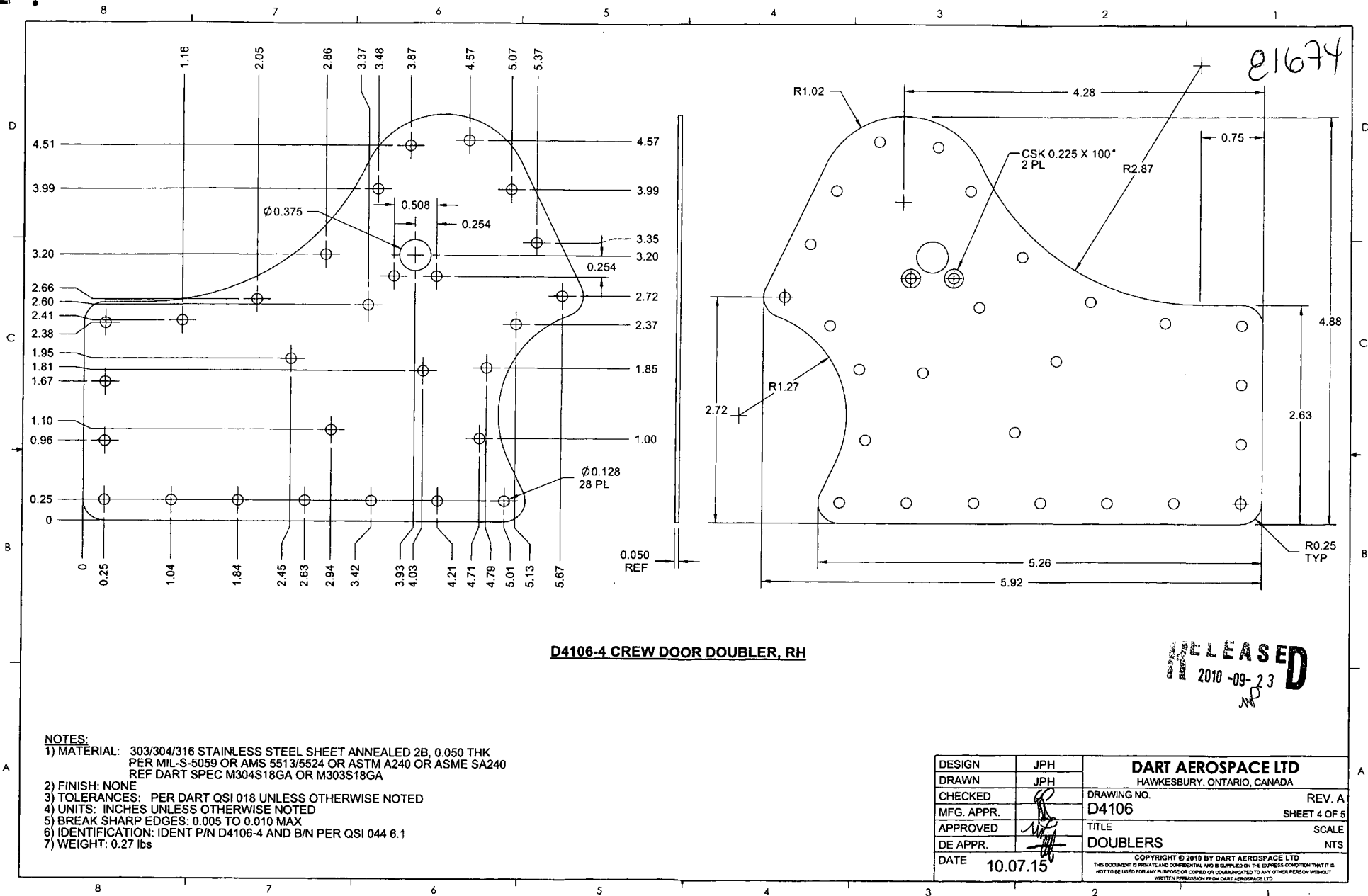
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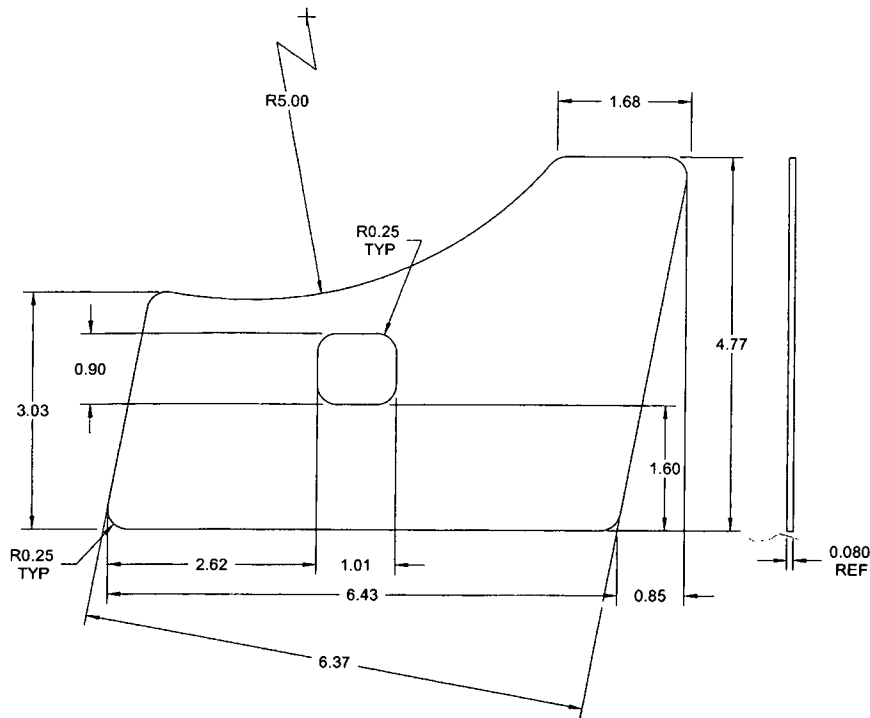
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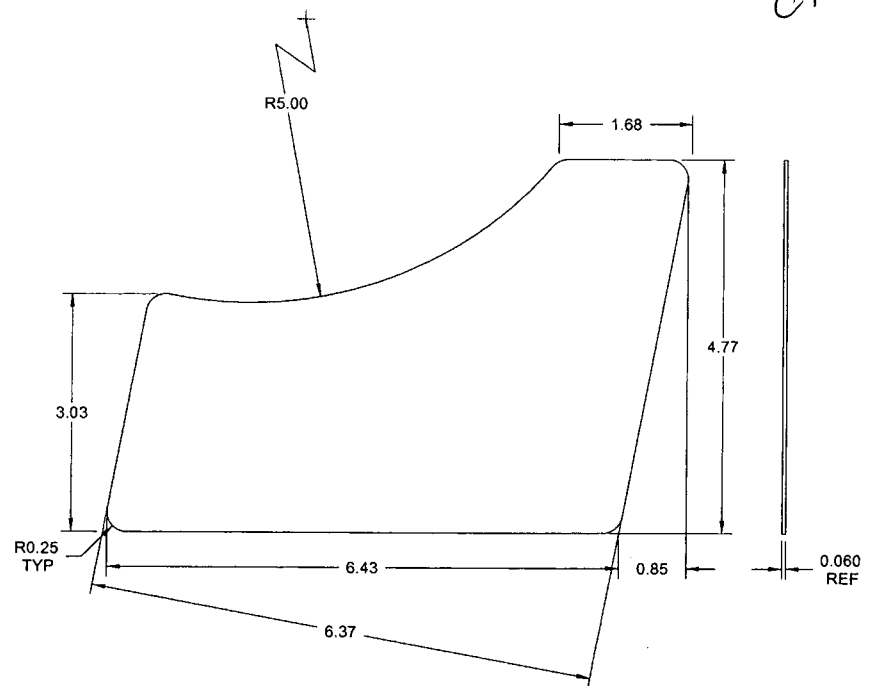
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**NOTE:** Date & initial all entries

81674



**D4106-5 SPACER, SILL DOUBLER**



**D4106-7 TEMPLATE**

**NOTES:**

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK  
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
- 7: LEXAN 9034 SHEET, 0.060 THK  
REF DART MLEXS.060-9034-08  
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.  
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs  
-7: N/A

**RELEASED**  
2010-09-23  
JPH

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. <b>D4106</b>	REV. A
MFG. APPR.	JPH		SHEET 5 OF 5
APPROVED	JPH	TITLE <b>DOUBLERS</b>	SCALE
DE APPR.	JPH		NTS
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